

Date: Thursday, 05/02/2009 3:44:12 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206B UTILITY BASKET		
Job Number	: 45545					
Estimate Number	: 10691					
P.O. Number	:			Part Number	: D206540013	
This Issue	: 05/02/2009		S.O. No. :	Drawing Number	: D206-540 REV H	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type : LARGE FAB ASSY	Drawing Revision	: H	
Previous Run	: 31456			Material	:	
Written By	:			Due Date	: 28/02/2009	
Checked & Approved By	: <u>JUL 09 02 09</u>			Qty:	1 Um: Each	
Comment	: Est Rev:H 02.08.15 Added D2749-1KJ					
	: Est Rev:I 07-03-20 As per DSI9361 JLM					

Additional Product

Job Number:



Spf

Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD206-540-013 CHG003	
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick: Assembly Kit	
3.0	45545A	206B BASKET LID - UNDER REVIEW	
		Comment: Sub-Component 206B BASKET BASE 1 x D2330-043 Batch _____	
4.0	45545B	206B BASKET BASE - UNDER REVIEW	
		Comment: Sub-Component 206B BASKET BASE 1 x D2330-041 Batch _____	
5.0	D2332041	Lid Prop Assembly 6.69" long	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D2332-041 Prop Ass'y _____	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	D2530	Handle Weldment 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 1 D2530 Handle Weldment _____		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 D2537 Bushing _____		
7.0	D2537	Bushing 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 1 D2569 Hinge _____		
8.0	D2569	Hinge 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 D2535 Spring _____		
9.0	D2535	Spring 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 D2931 Bumper _____		
10.0	D2931	Bumper 
Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 38 AD64ABS Pop Rivets _____		
11.0	AD64ABS	Pop Rivets 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	MS20600AD4W3	Cherry Rivets
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 MS20600AD4W3 Rivet _____	
13.0	AN316A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 AN3-16A Bolt _____	
14.0	AN422A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 AN4-22A Bolt _____	
15.0	AN517A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 4 AN5-17A Bolt _____	
16.0	AN960JD416L	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 AN960JD416L Washer _____	
17.0	AN960JD516	Washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 4 AN960JD516 Washer _____	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
18.0	AN9704	Washer
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Assemby Kit		
Qty Part Number Description Batch		
4 AN970-4 Washer _____		
19.0	MS21042L3	Nut
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Assemby Kit		
Qty Part Number Description Batch		
2 MS21042L3 Nut (or -3) _____		
20.0	MS21042L4	Nut
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Assemby Kit		
Qty Part Number Description Batch		
2 MS21042L4 Nut (or -4) _____		
21.0	MS21042L5	Nut
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Assemby Kit		
Qty Part Number Description Batch		
4 MS21042L5 Nut (or -5) _____		
22.0	AN960JD8	Washer
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Assemby Kit		
Qty Part Number Description Batch		
2 AN960JD8 Washer _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
23.0	D2330041	Basket Base Assembly
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 1 D2330-041 Basket Base _____</p>		
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 1 D2330-043 Lid _____</p>		
25.0	D33963	Spacer
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Spacer Batch: _____</p>		
26.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D206-540</p>		
27.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP</p>		
28.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Pick: Packing Kit</p>		
29.0	D2249041	Fitting Assembly
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2249-041 Braket _____</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
30.0	D2022101	Spacer
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit 4 D2022-101 Spacer _____
31.0	D2012107	Clevis
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2012-107 Clevis _____
32.0	D2259	Label
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2259 Placard _____
33.0	D2525	Spacer
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2525 Spacer kit _____
34.0	D2526	Bushing
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2526 Bushing _____
35.0	D2748	Clevis
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2748 Clevis _____
36.0	D27491	Strut
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2749-1 Strut _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
37.0	D27493	Strut 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2749-3 Strut
38.0	D2814	Strut 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2814 Strut
39.0	AN412A	Bolt 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 2 AN4-12A Bolt
40.0	AN412	Bolt 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 AN4-12 Bolt
41.0	AN45A	Bolt 
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Packing Kit 8 AN4-5A Bolt
42.0	AN517A	Bolt 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 AN5-17A Bolt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
43.0	AN421A	Bolt
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Packing Kit		
2 AN4-21A Bolt _____		
44.0	AN960JD416	Washer
		
Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)		
Pick: Packing Kit		
Qty Part Number Description Batch		
19 AN960JD416 Washer _____		
45.0	AN960JD516	Washer
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Packing Kit		
2 AN960JD516 Washer _____		
46.0	AN9704	Washer
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick: Packing Kit		
1 AN970-4 Washer _____		
47.0	MS21042L4	Nut
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Packing Kit		
Qty Part Number Description Batch		
4 MS21042L4 Nut (or -4) _____		
48.0	MS21042L5	Nut
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: Packing Kit		
2 MS21042L5 Nut _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:13 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 45545

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
49.0	MS27039411	Screw
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 MS27039-4-11 Screw	
50.0	AN46	Bolts
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 AN4-6 Bolt	
51.0	AN3204	Nut
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Pick: Packing Kit 3 AN320-4 Nut	
52.0	AN38022	Cotter Pins
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Pick: Packing Kit 3 AN380-2-2 Cotter pin	
53.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	
54.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D206-540-013 Location: _____ PPP Rev: _____	
55.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	
	Job Completion	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries